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(54) **FLOW REVERSING EXHAUST GAS MIXER**

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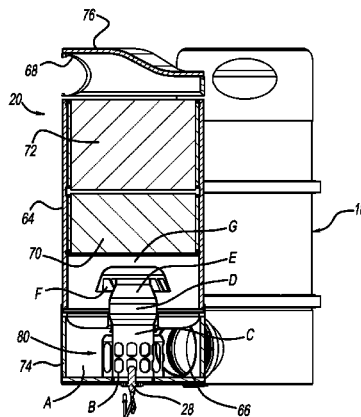
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(57) **ABSTRACT**

An exhaust mixing device for mixing an exhaust produced by an engine with a reagent exhaust treatment fluid that is dosed into the exhaust from a dosing module. The exhaust mixing device includes a decomposition tube having a first end and a second end. The first end of the decomposition tube is configured to receive the exhaust and the reagent exhaust treatment fluid. A flow reversing device is positioned at the second end of the decomposition tube. The flow reversing device includes a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions, wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube.

24 Claims, 17 Drawing Sheets



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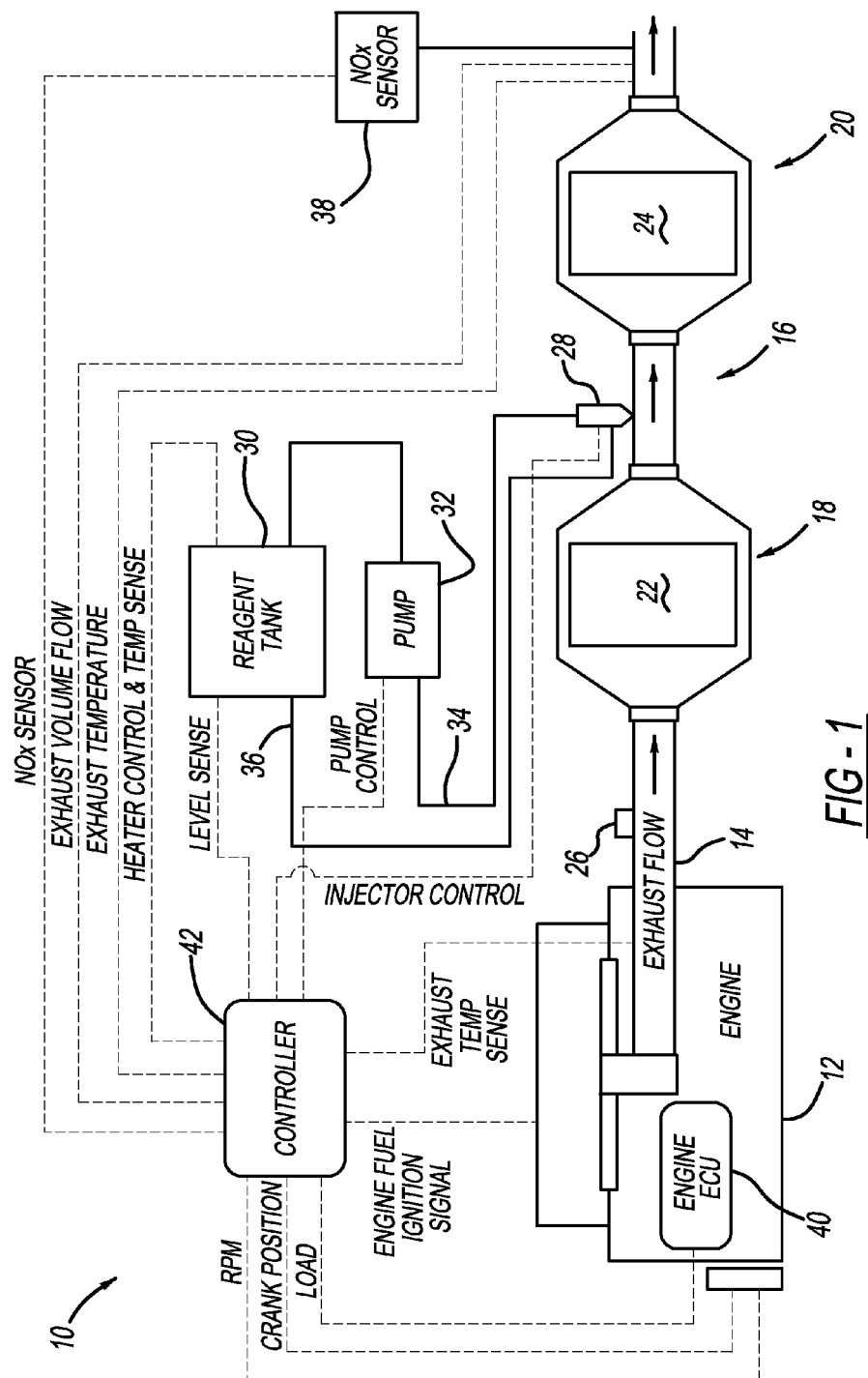
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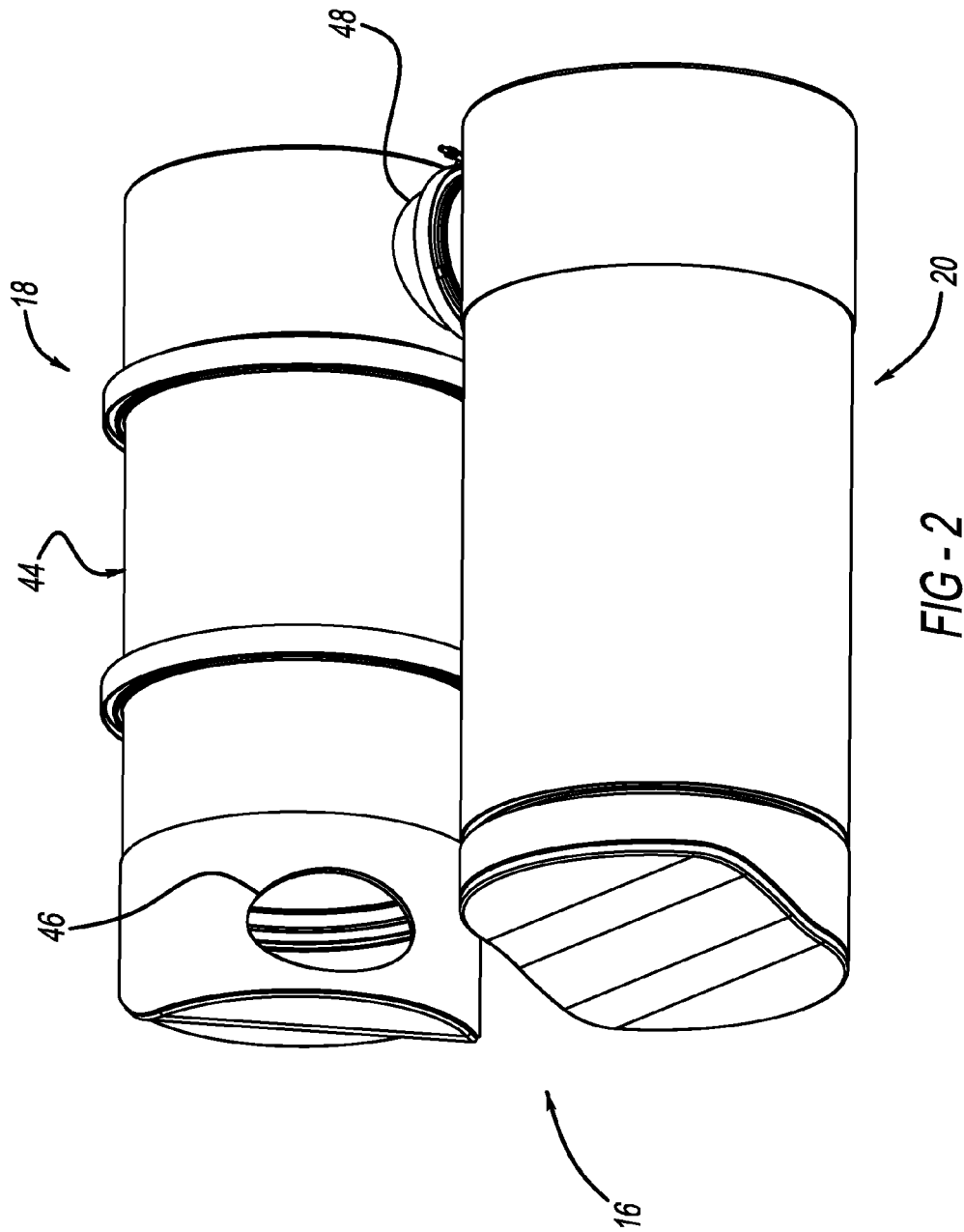
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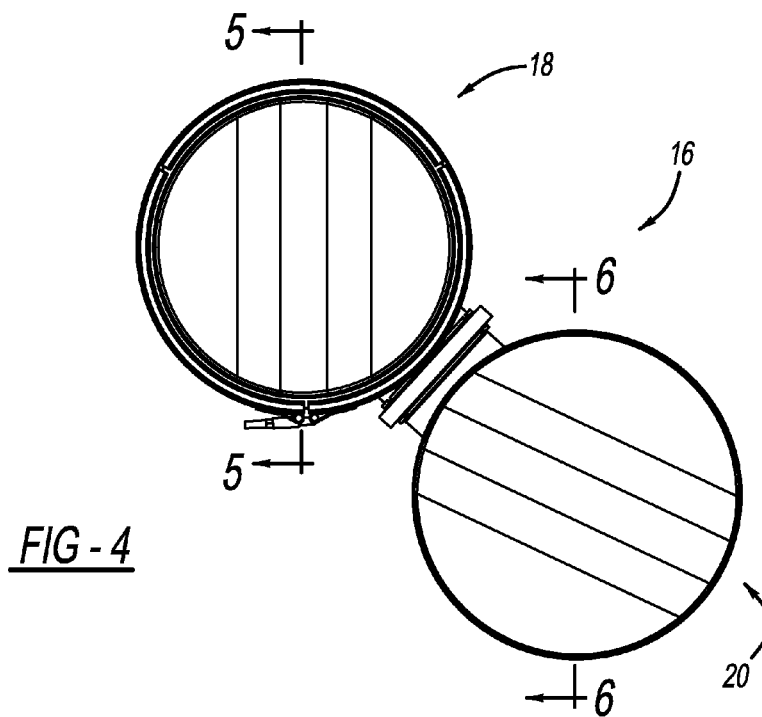
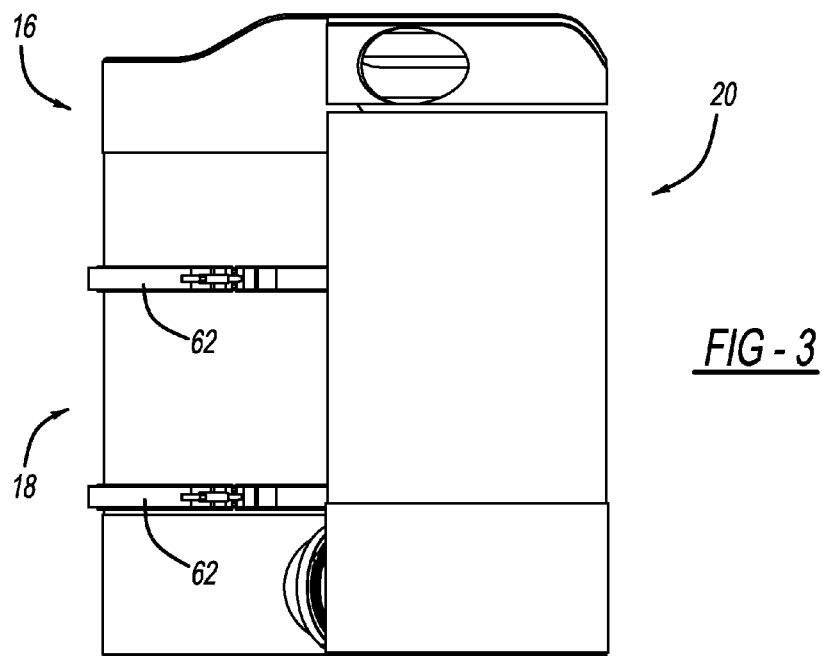
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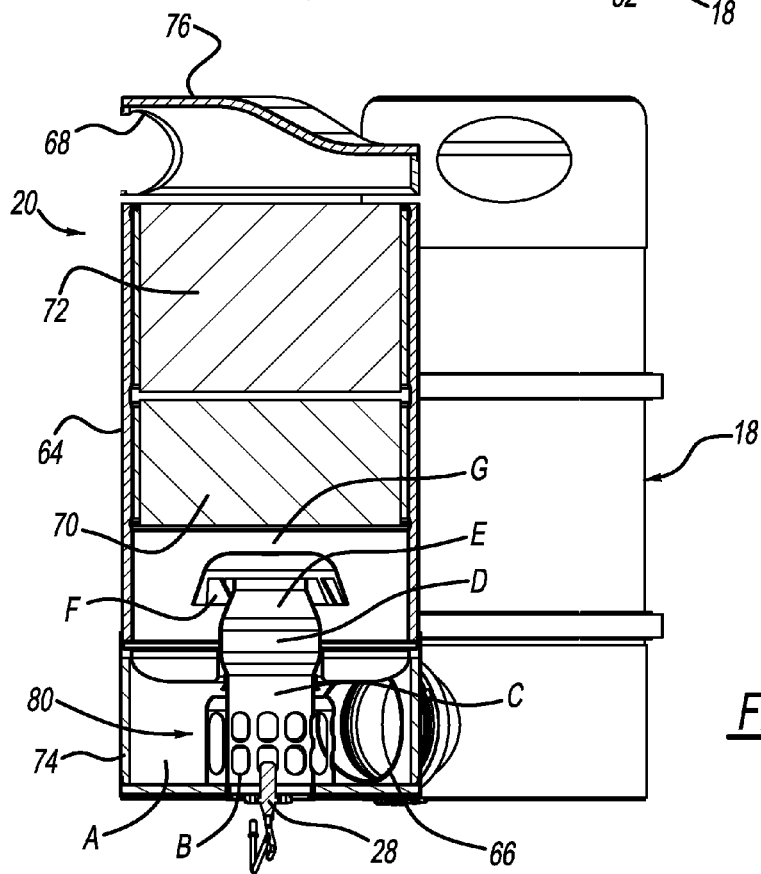
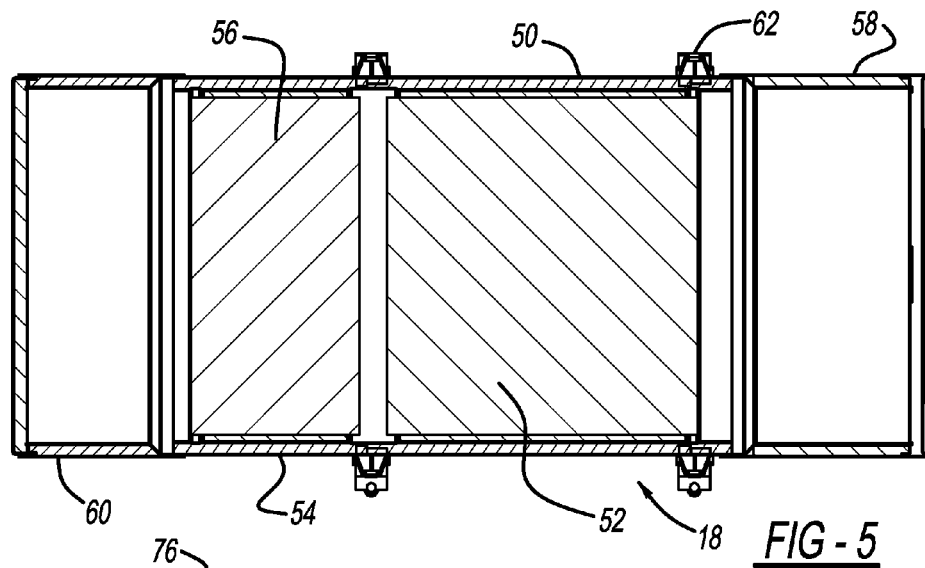
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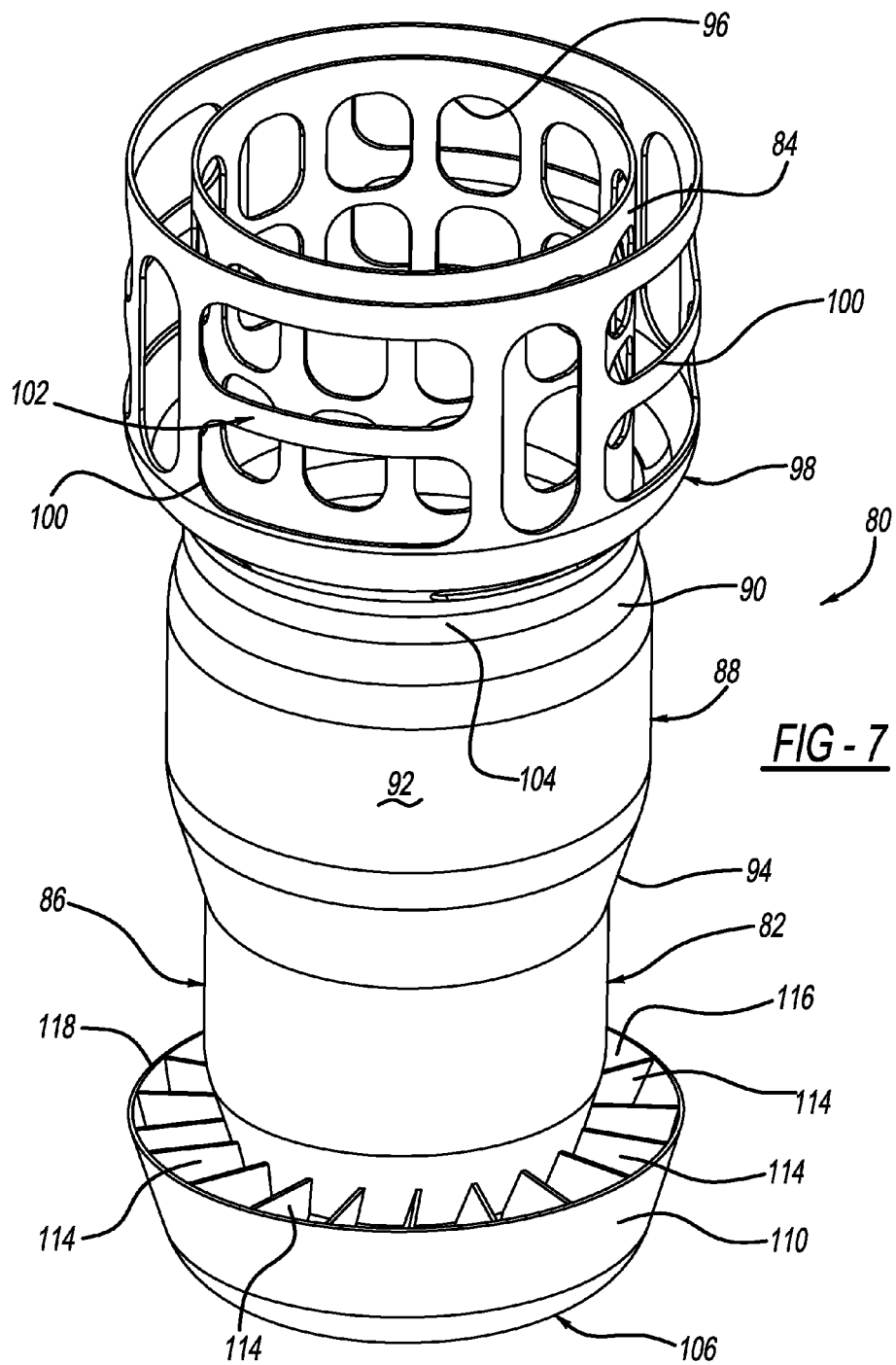
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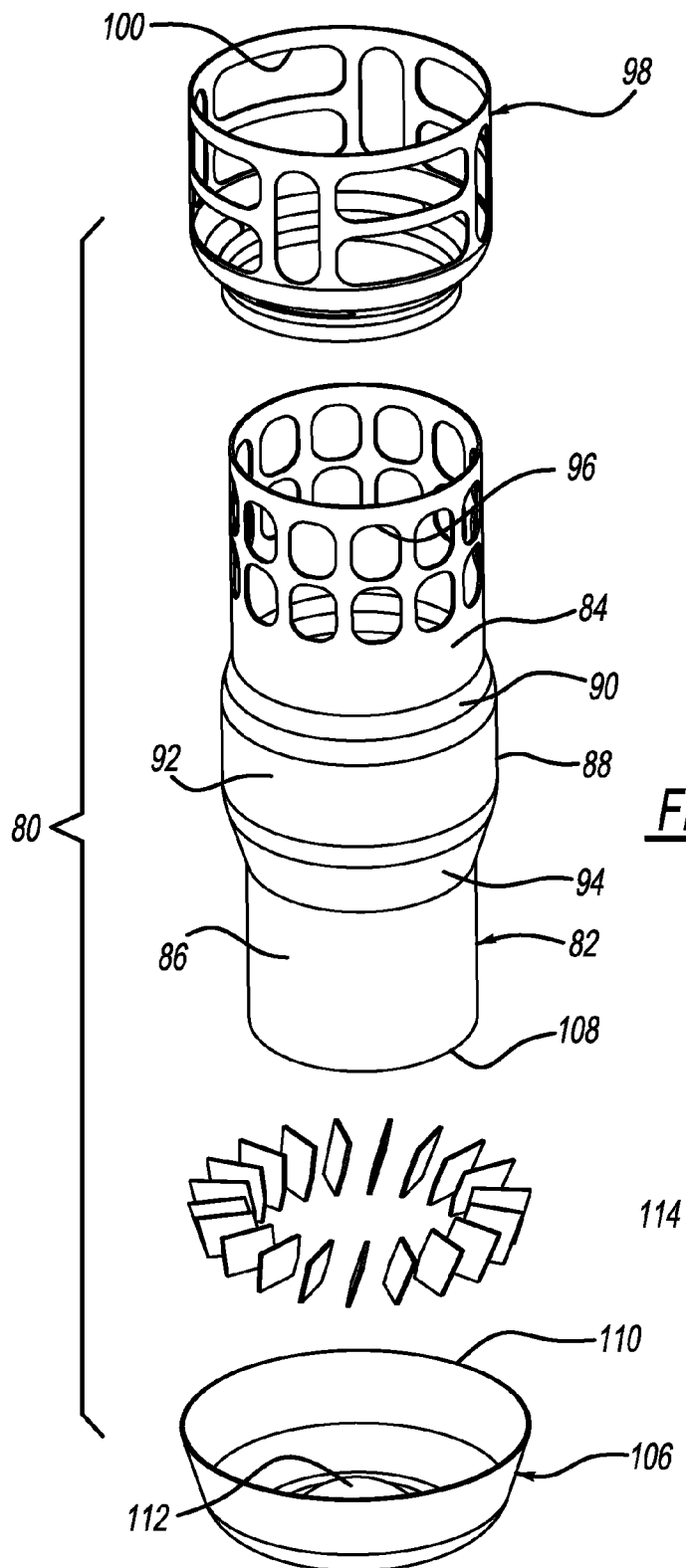


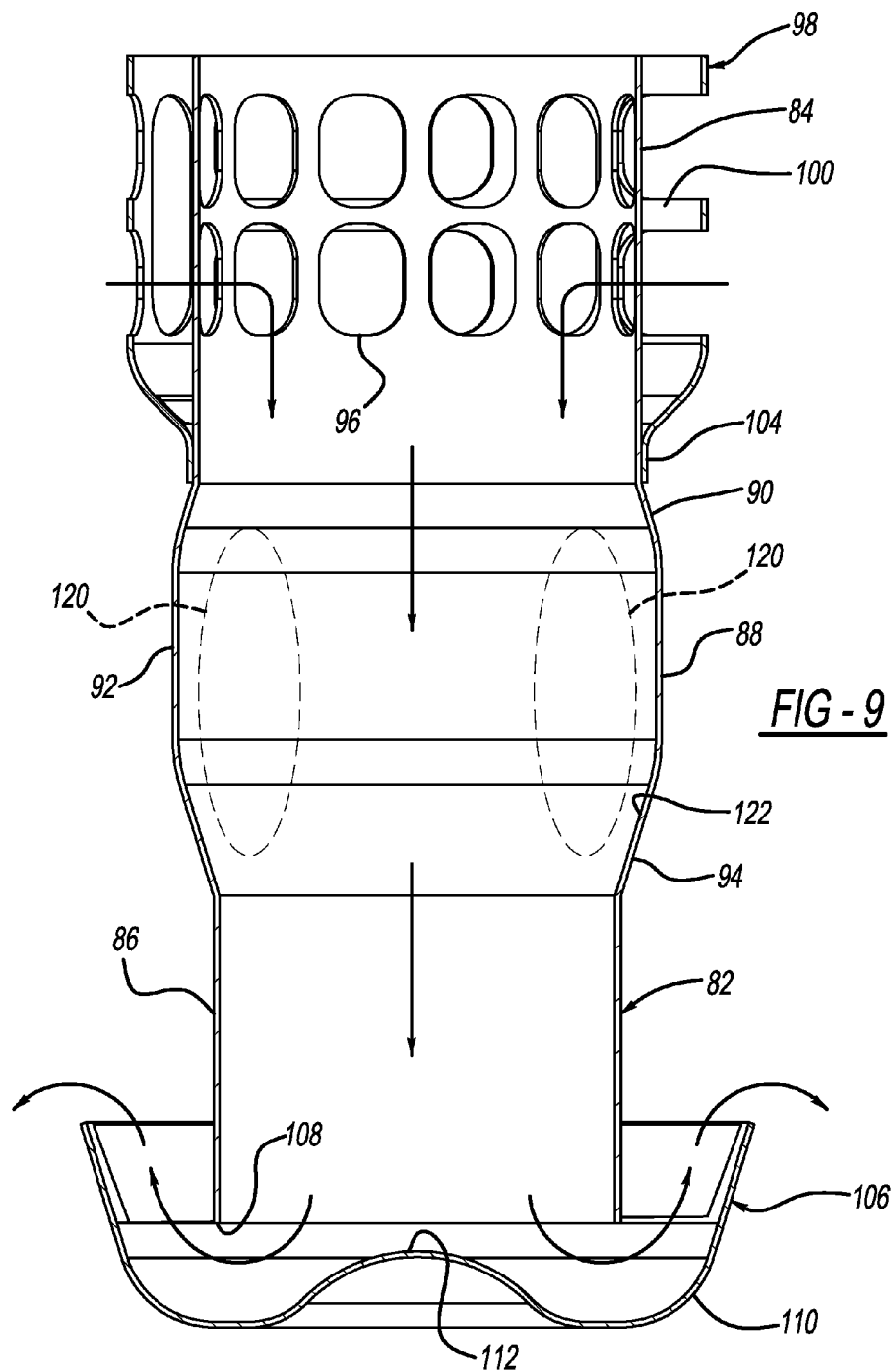


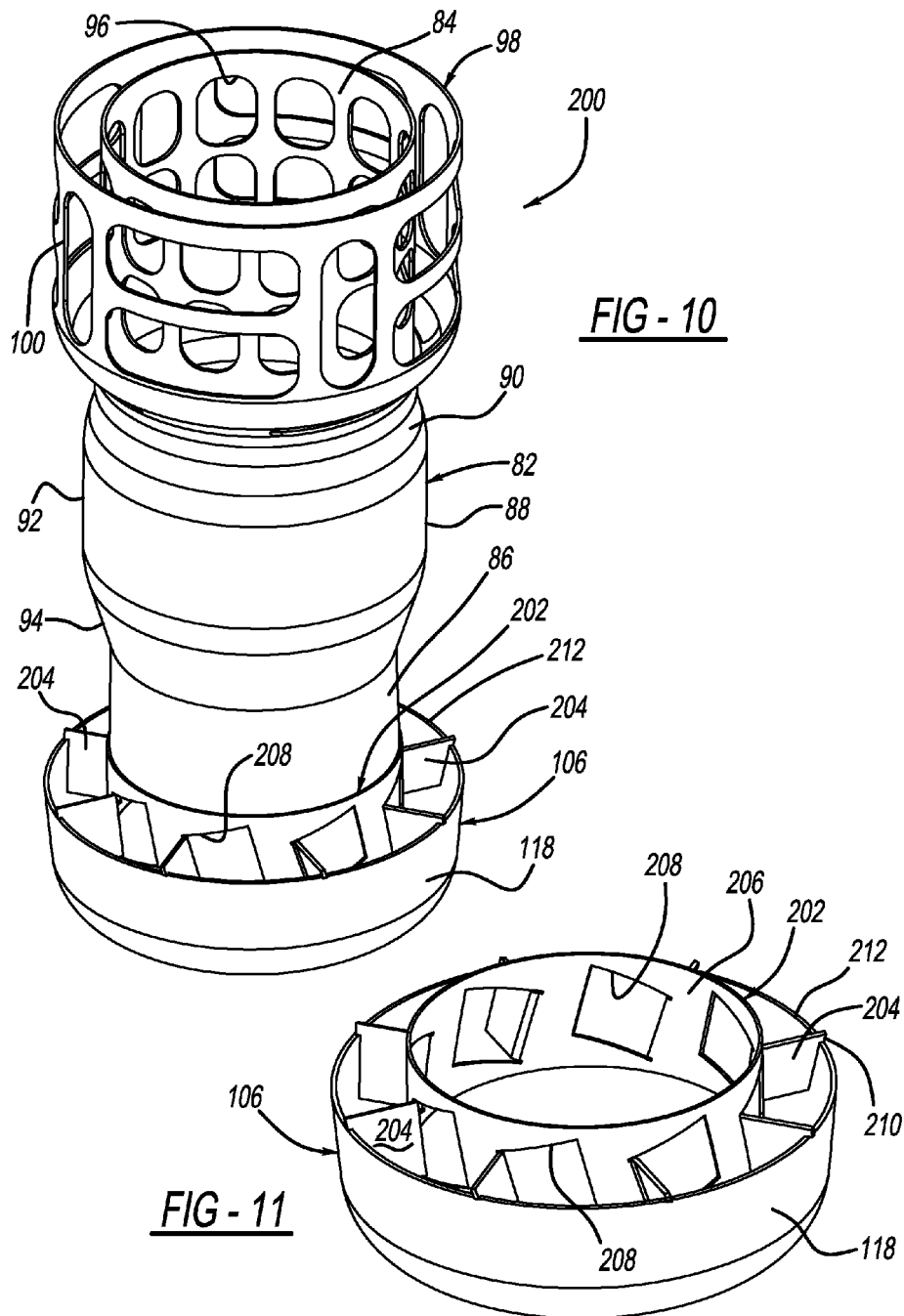












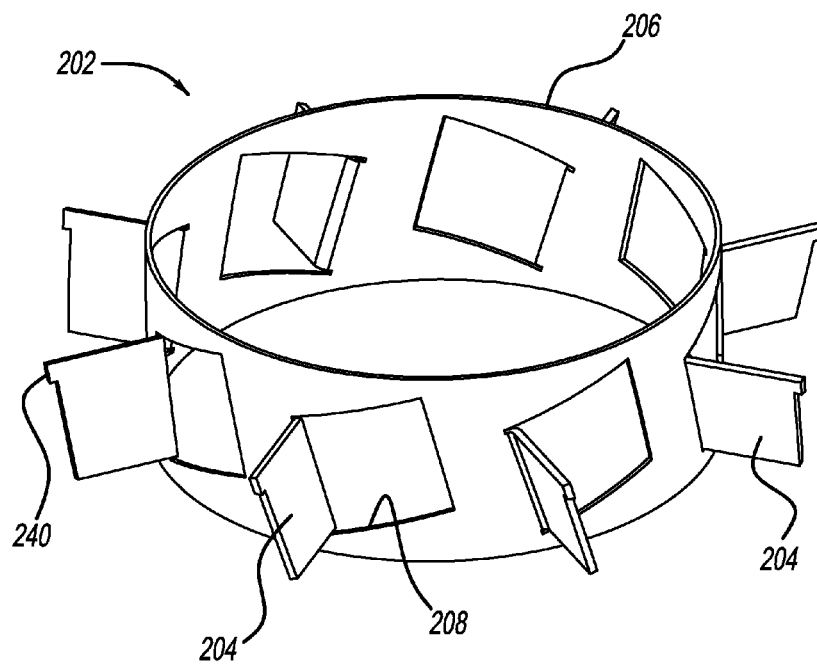


FIG - 12

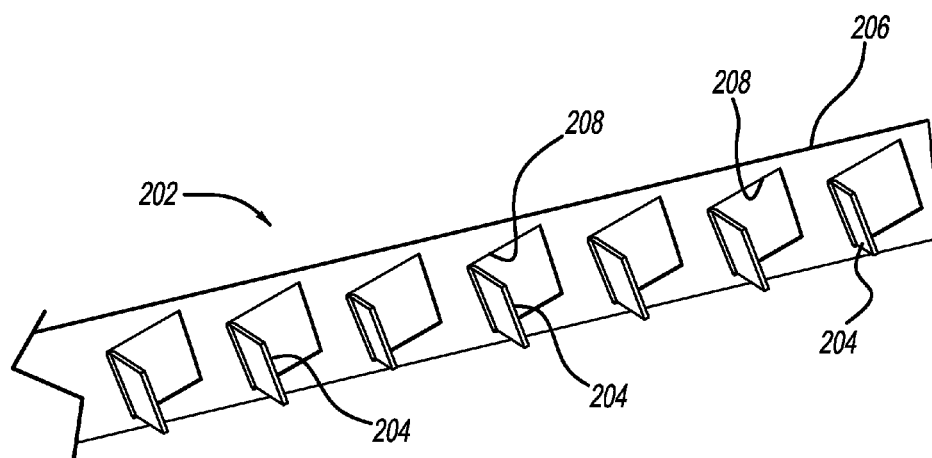
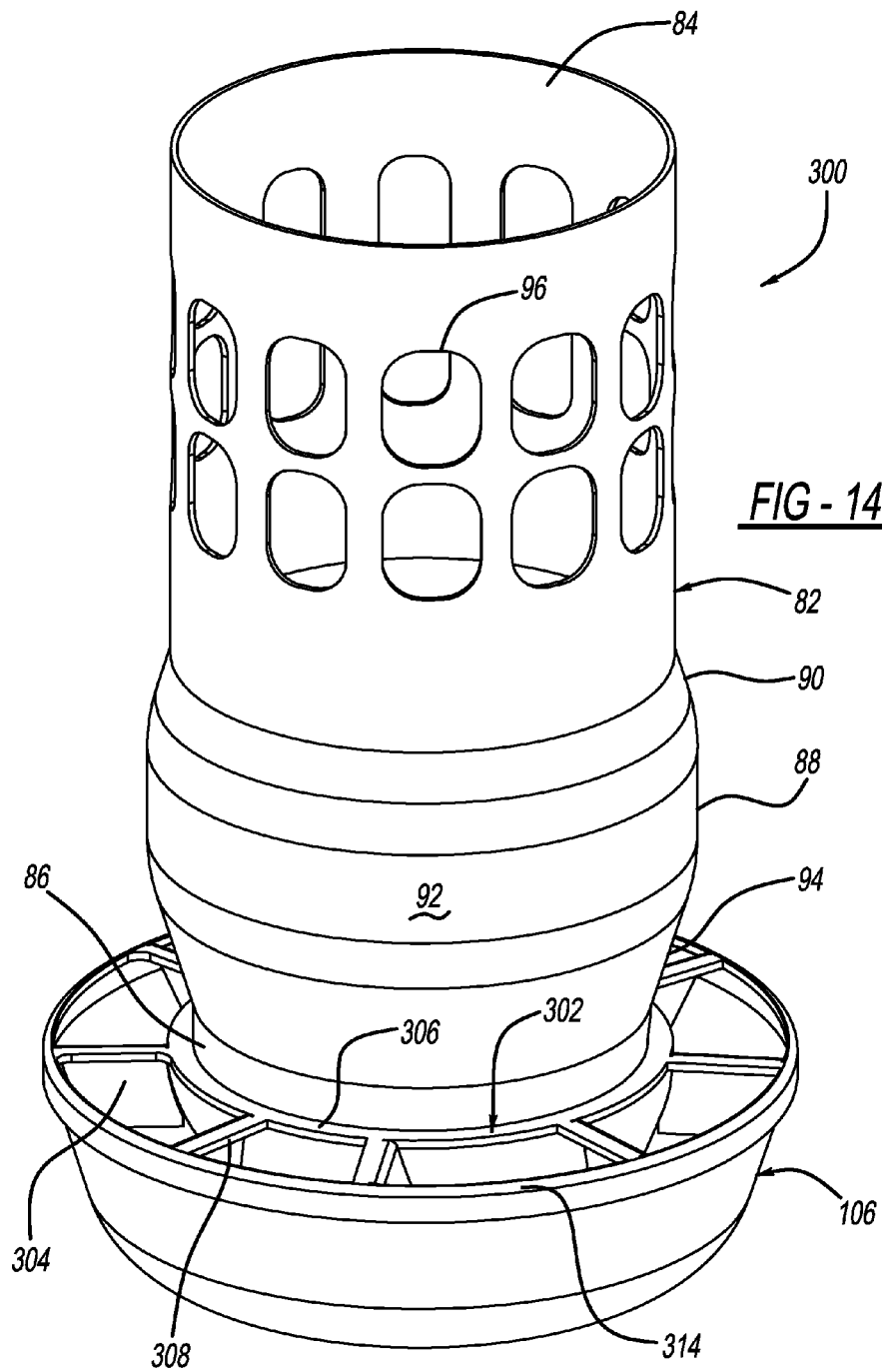
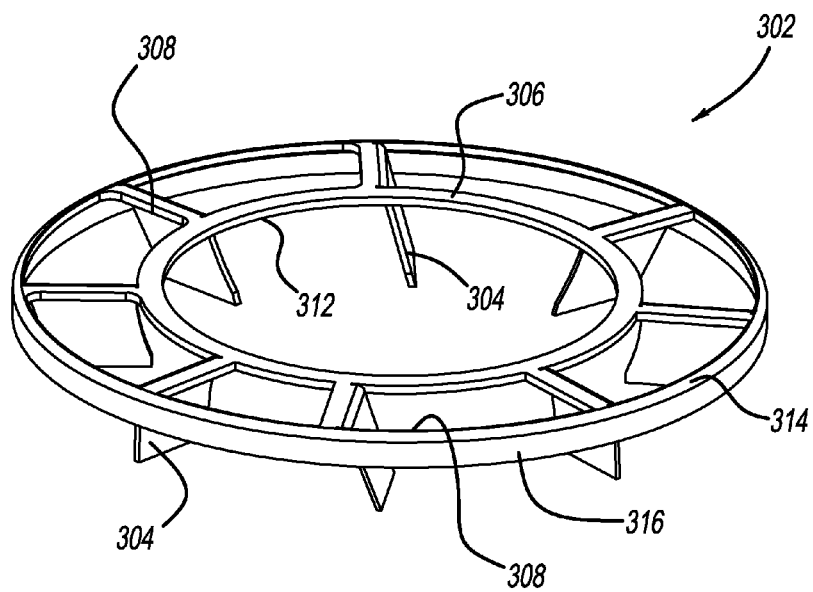
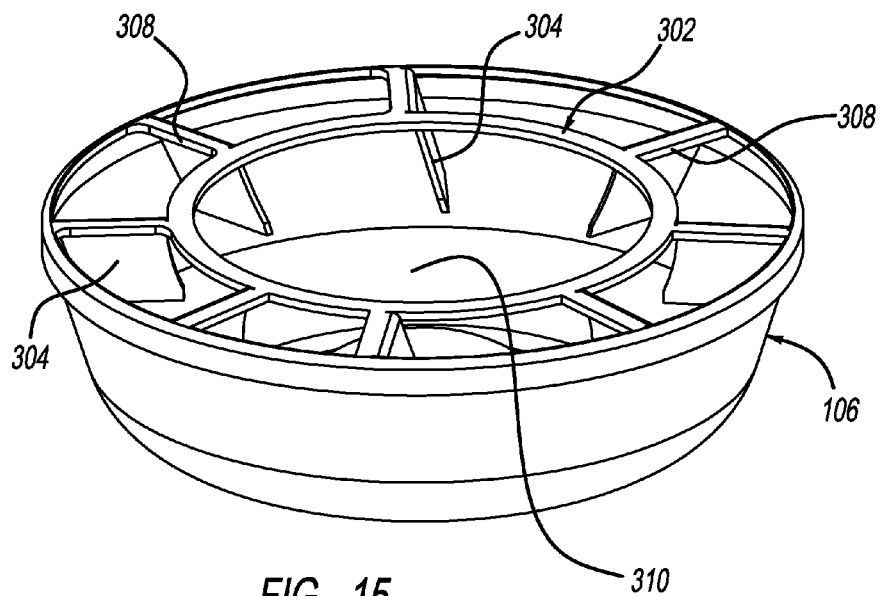
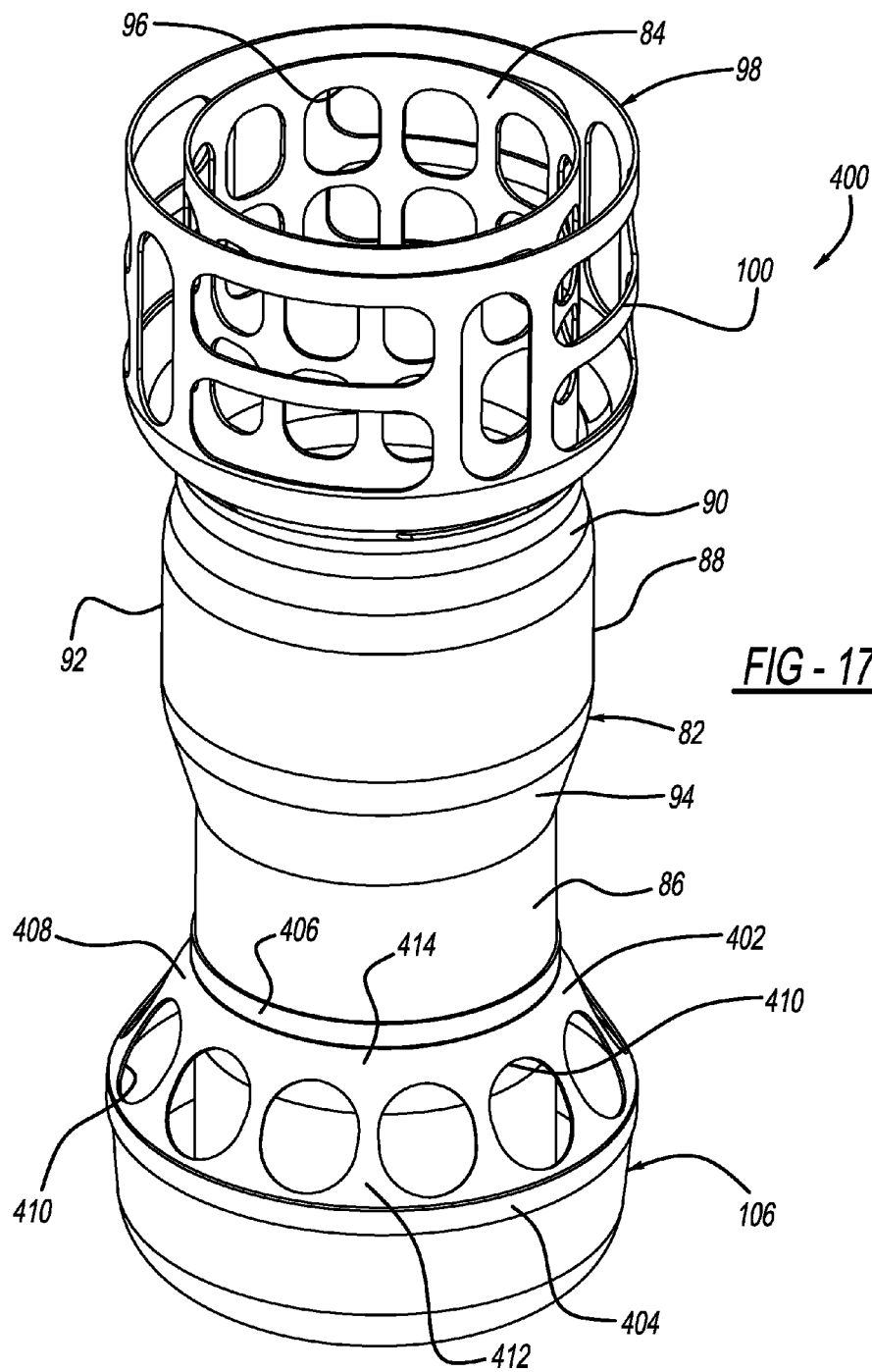
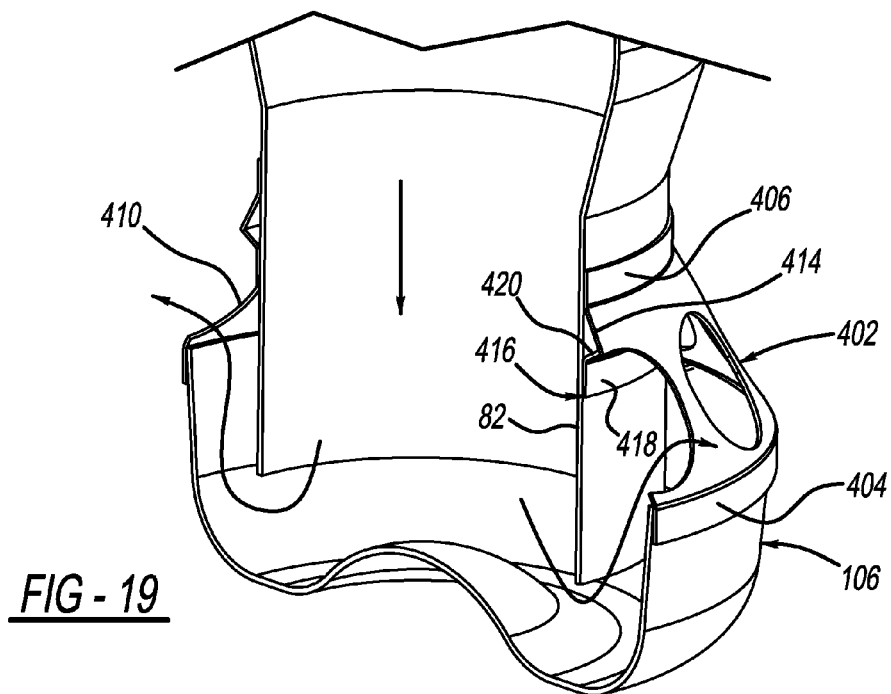
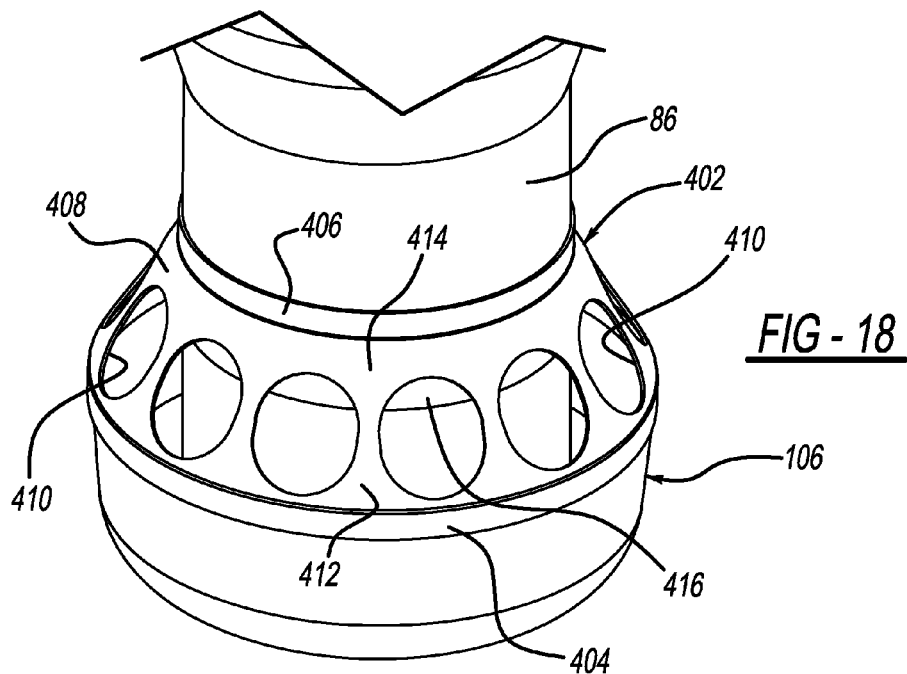


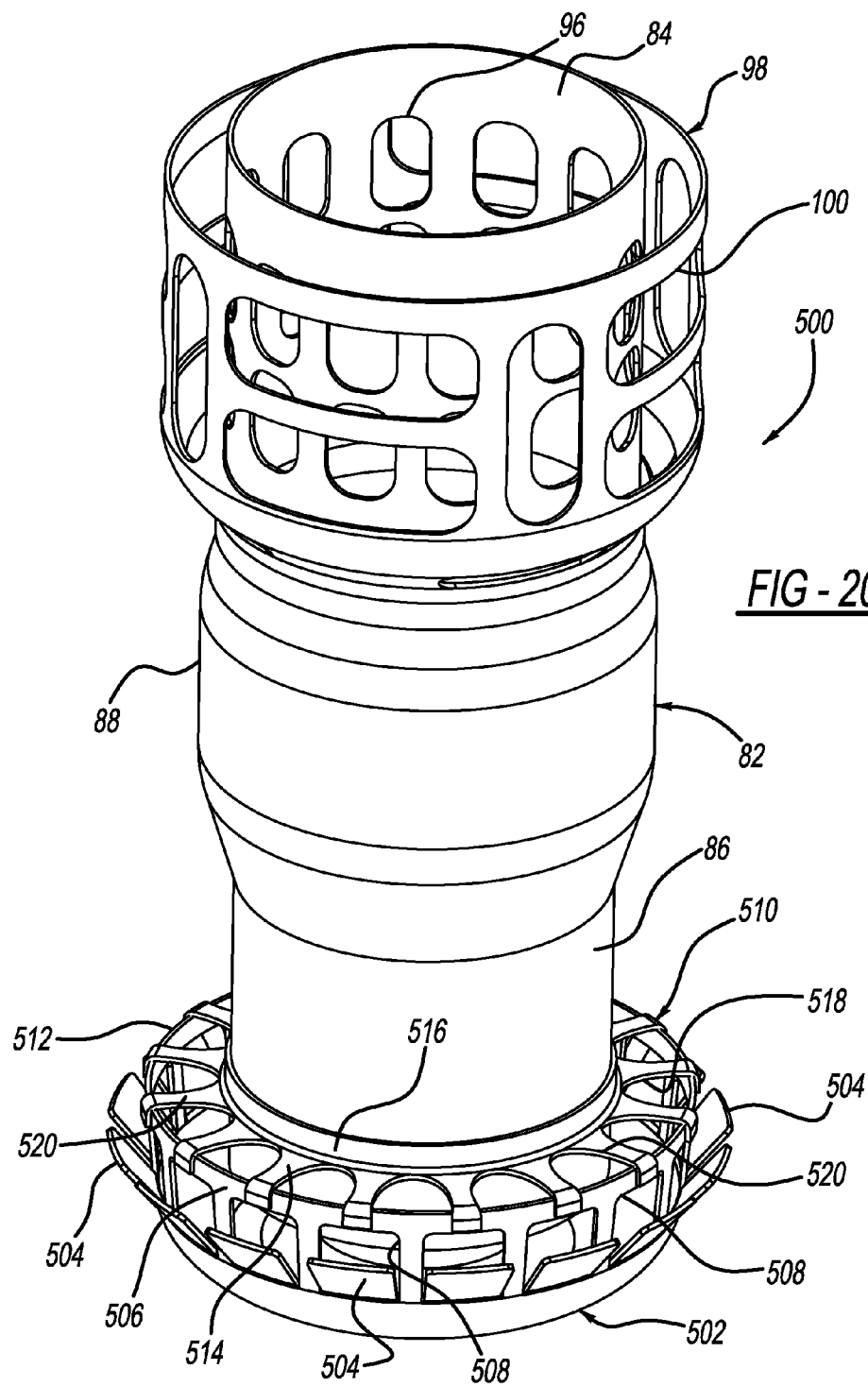
FIG - 13

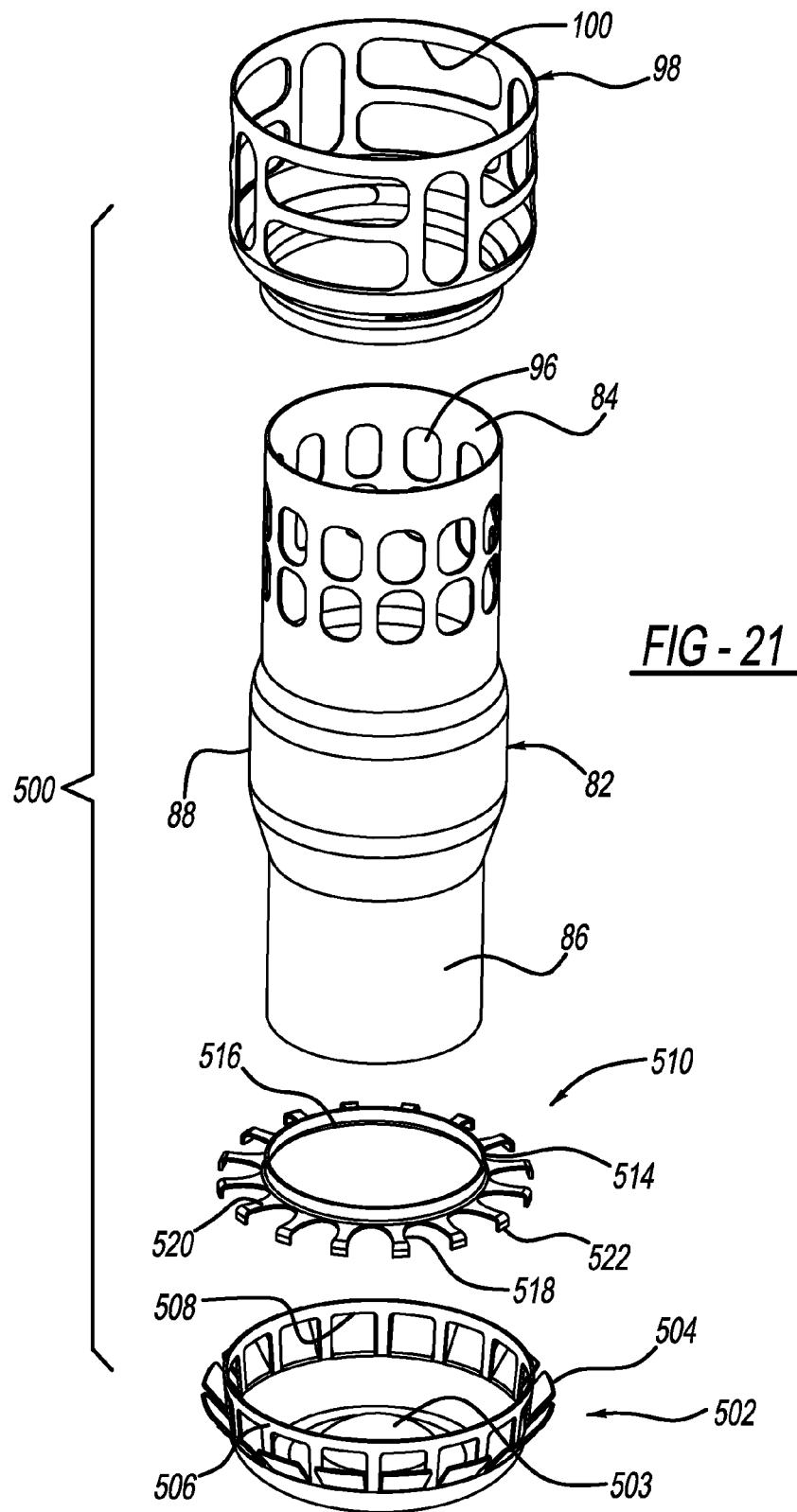


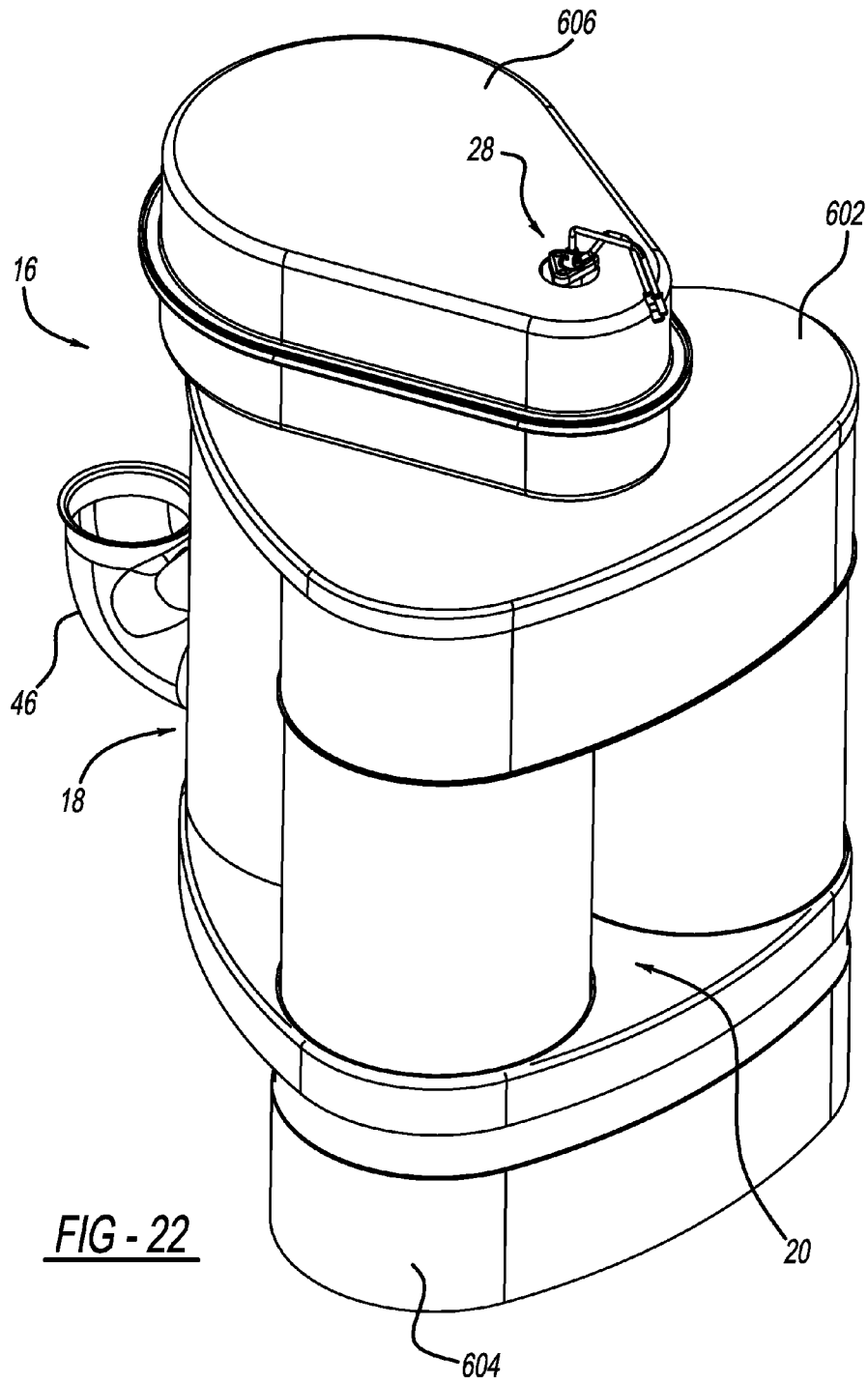


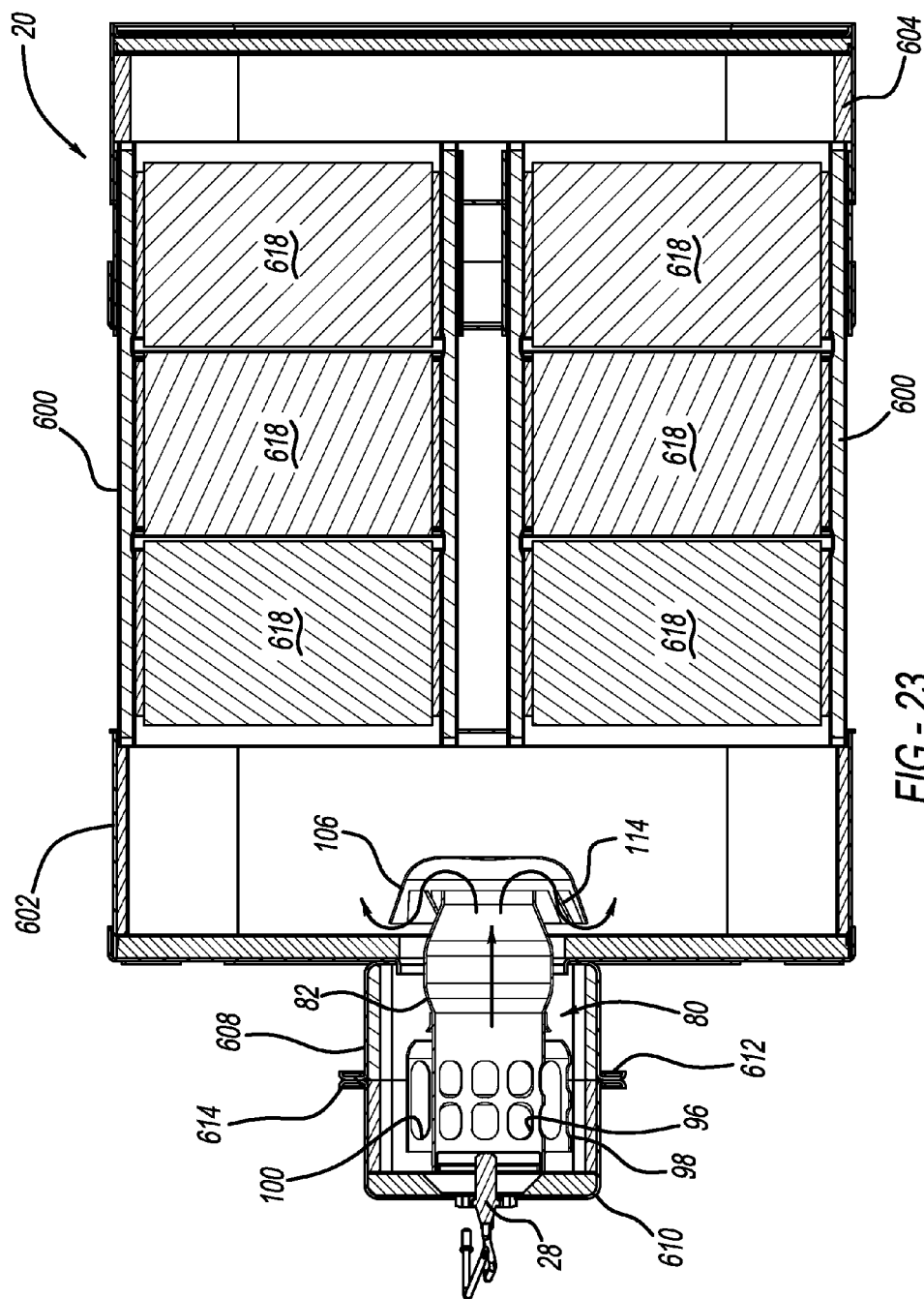












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FLOW REVERSING EXHAUST GAS MIXER**FIELD**

The present disclosure relates to an exhaust after-treatment system including an exhaust gas mixing device.

BACKGROUND

This section provides background information related to the present disclosure which is not necessarily prior art.

Exhaust after-treatment systems may dose a reagent exhaust treatment fluid into the exhaust stream before the exhaust stream passes through various exhaust after-treatment components. A urea exhaust treatment fluid, for example, may be dosed into the exhaust stream before the exhaust passes through a selective catalytic reduction (SCR) catalyst. The SCR catalyst is most effective, however, when the exhaust has sufficiently mixed with the urea exhaust treatment fluid.

SUMMARY

This section provides a general summary of the disclosure, and is not a comprehensive disclosure of its full scope or all of its features.

The present disclosure provides an exhaust mixing device for mixing an exhaust produced by an engine with a reagent exhaust treatment fluid that is dosed into the exhaust from a dosing module. The exhaust mixing device includes a decomposition tube having a first end and a second end. The first end of the decomposition tube is configured to receive the exhaust and the reagent exhaust treatment fluid. A flow reversing device is positioned at the second end of the decomposition tube. The flow reversing device includes a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions, wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube.

Further areas of applicability will become apparent from the description provided herein. The description and specific examples in this summary are intended for purposes of illustration only and are not intended to limit the scope of the present disclosure.

DRAWINGS

The drawings described herein are for illustrative purposes only of selected embodiments and not all possible implementations, and are not intended to limit the scope of the present disclosure.

FIG. 1 is a schematic representation of an exhaust system according to a principle of the present disclosure;

FIG. 2 is a perspective view of an exhaust treatment component according to a principle of the present disclosure;

FIG. 3 is a side-perspective view of the exhaust treatment component illustrated in FIG. 2;

FIG. 4 is a front-perspective view of the exhaust treatment component illustrated in FIG. 2;

FIG. 5 is a cross-sectional view along line 5-5 in FIG. 4;

FIG. 6 is a cross-sectional view along line 6-6 in FIG. 4;

FIG. 7 is a perspective view of a mixing assembly according to a first exemplary embodiment of the present disclosure;

FIG. 8 is an exploded perspective view of the mixing assembly illustrated in FIG. 7;

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FIG. 9 is a cross-sectional view of the mixing assembly illustrated in FIG. 7;

FIG. 10 is a perspective view of a mixing assembly according to a second exemplary embodiment of the present disclosure;

FIG. 11 is a perspective view of a flow-reversing device and dispersion device of the mixing assembly illustrated in FIG. 10;

FIG. 12 is a perspective view of the dispersion device illustrated in FIG. 11 in an assembled state;

FIG. 13 is another perspective view of the dispersion device illustrated in FIG. 11 in an un-assembled state;

FIG. 14 is a perspective view of a mixing assembly according to a third exemplary embodiment of the present disclosure;

FIG. 15 is a perspective view of a flow-reversing device and dispersion device of the mixing assembly illustrated in FIG. 14;

FIG. 16 is a perspective view of the dispersion device illustrated in FIG. 15;

FIG. 17 is a perspective view of a mixing assembly according to a fourth exemplary embodiment of the present disclosure;

FIG. 18 is a partial-perspective view of the mixing assembly illustrated in FIG. 17;

FIG. 19 is a perspective cross-sectional view of FIG. 17;

FIG. 20 is a perspective view of a mixing assembly according to a fifth exemplary embodiment of the present disclosure;

FIG. 21 is an exploded perspective view of the mixing assembly illustrated in FIG. 10;

FIG. 22 is a perspective view of an exhaust treatment component according to a principle of the present disclosure; and

FIG. 23 is a cross-sectional view of the exhaust treatment component illustrated in FIG. 22.

Corresponding reference numerals indicate corresponding parts throughout the several views of the drawings.

DETAILED DESCRIPTION

Example embodiments will now be described more fully with reference to the accompanying drawings.

FIG. 1 schematically illustrates an exhaust system 10 according to the present disclosure. Exhaust system 10 can include at least an engine 12 in communication with a fuel source (not shown) that, once consumed, will produce exhaust gases that are discharged into an exhaust passage 14 having an exhaust after-treatment system 16. Downstream from engine 12 can be disposed a pair of exhaust treatment components 18 and 20, which can include catalyst-coated substrates or filters 22 and 24. Catalyst-coated substrates or filters 22 and 24 can be any combination of a diesel particulate filter (DPF), a diesel oxidation catalyst (DOC), a selective catalytic reduction (SCR) component, a lean NO_x catalyst, an ammonia slip catalyst, or any other type of exhaust treatment device known to one skilled in the art. If a DPF is used, it may be catalyst-coated.

Although not required by the present disclosure, exhaust after-treatment system 16 can further include components such as a thermal enhancement device or burner 26 to increase a temperature of the exhaust gases passing through exhaust passage 14. Increasing the temperature of the exhaust gas is favorable to achieve light-off of the catalyst in the exhaust treatment component 18 in cold-weather conditions and upon start-up of engine 12, as well as initiate regeneration of the exhaust treatment component 18 when the exhaust treatment substrate 22 or 24 is a DPF.

To assist in reduction of the emissions produced by engine 12, exhaust after-treatment system 16 can include a dosing module 28 for periodically dosing an exhaust treatment fluid into the exhaust stream. As illustrated in FIG. 1, dosing module 28 can be located upstream of exhaust treatment component 18, and is operable to inject an exhaust treatment fluid into the exhaust stream. In this regard, dosing module 28 is in fluid communication with a reagent tank 30 and a pump 32 by way of inlet line 34 to dose an exhaust treatment fluid such as diesel fuel or urea into the exhaust passage 14 upstream of exhaust treatment components 18 and 20. Dosing module 28 can also be in communication with reagent tank 30 via return line 36. Return line 36 allows for any exhaust treatment fluid not dosed into the exhaust stream to be returned to reagent tank 30. Flow of the exhaust treatment fluid through inlet line 34, dosing module 28, and return line 36 also assists in cooling dosing module 28 so that dosing module 28 does not overheat. Although not illustrated in the drawings, dosing module 28 can be configured to include a cooling jacket that passes a coolant around dosing module 28 to cool it.

The amount of exhaust treatment fluid required to effectively treat the exhaust stream may vary with load, engine speed, exhaust gas temperature, exhaust gas flow, engine fuel injection timing, desired NO_x reduction, barometric pressure, relative humidity, EGR rate and engine coolant temperature. A NO_x sensor or meter 38 may be positioned downstream from exhaust treatment component 18. NO_x sensor 38 is operable to output a signal indicative of the exhaust NO_x content to an engine control unit 40. All or some of the engine operating parameters may be supplied from engine control unit 40 via the engine/vehicle databus to a reagent electronic dosing controller 42. The reagent electronic dosing controller 42 could also be included as part of the engine control unit 40. Exhaust gas temperature, exhaust gas flow and exhaust back pressure and other vehicle operating parameters may be measured by respective sensors, as indicated in FIG. 1.

The amount of exhaust treatment fluid required to effectively treat the exhaust stream can also be dependent on the size of the engine 12. In this regard, large-scale diesel engines used in locomotives, marine applications, and stationary applications can have exhaust flow rates that exceed the capacity of a single dosing module 28. Accordingly, although only a single dosing module 28 is illustrated for dosing exhaust treatment fluid, it should be understood that multiple dosing modules 28 for reagent injection are contemplated by the present disclosure.

Referring to FIGS. 2-6, an exemplary configuration of exhaust treatment components 18 and 20 is illustrated. As best shown in FIG. 2, exhaust treatment components 18 and 20 are arranged parallel to one another. It should be understood, however, that exhaust treatment components 18 and 20 can be arranged substantially co-axially, without departing from the scope of the present disclosure.

Exhaust treatment component 18 may include a housing 44, an inlet 46, and an outlet 48. Inlet 46 may be in communication with exhaust passage 14, and outlet 48 may be in communication with exhaust treatment component 20. Although outlet 48 is illustrated as being directly connected to exhaust treatment component 20, it should be understood that an additional conduit (not shown) may be positioned between outlet 48 and exhaust treatment component 20. The additional conduit can be non-linear such that the flow of exhaust through the conduit must turn before entering exhaust treatment component 20. Housing 44 can be cylindrically-shaped and may include a first section 50 supporting a DOC 52, and a second section 54 supporting DPF 56. Although DOC 52 is illustrated as being upstream of DPF 56, it should

be understood that DPF 56 can be positioned upstream of DOC 52 without departing from the scope of the present disclosure. Opposing ends of housing 44 can include end caps 58 and 60 to hermetically seal housing 44. End caps 58 and 60 can be slip-fit and welded to first and second sections 50 and 54, respectively. First and second sections 50 and 54 may be secured by clamps 62. The use of clamps 62 allows for easy removal of DOC 52 or DPF 56 for maintenance, cleaning, or replacement of these components. Exhaust from exhaust passage 14 will enter inlet 46, pass through DOC 52 and DPF 56, and exit outlet 48 before entering exhaust treatment component 20.

Exhaust treatment component 20 is substantially similar to exhaust treatment component 18. In this regard, exhaust treatment component 20 may include a housing 64, an inlet 66, and an outlet 68. Inlet 66 communicates with outlet 48 of exhaust treatment component 18, and outlet 68 may be in communication with a downstream section of exhaust passage 14.

Housing 64 can be cylindrically-shaped and may support an SCR 70 and ammonia slip catalyst 72. SCR is preferably located upstream of ammonia slip catalyst 72. Opposing ends of housing 64 can include end caps 74 and 76 to hermetically seal housing 64. End caps 74 and 76 can be slip-fit and welded to housing 64. Alternatively, end caps 74 and 76 can be secured to housing 64 by clamps (not shown). Exhaust from outlet 48 of exhaust treatment component 18 will enter inlet 66, pass through SCR 70 and ammonia slip catalyst 72, and exit outlet 68 before entering the downstream section of exhaust passage 14.

Dosing module 28 may be positioned on end cap 74 at a location proximate inlet 66. Dosing module 28 is operable to inject a reductant such as a urea exhaust treatment fluid into the exhaust stream before the exhaust stream passes through SCR 70. A sufficient intermingling of the exhaust and exhaust treatment fluid should occur to optimize the removal of NO_x from the exhaust stream during as the mixture passes through SCR 70. To assist in intermingling of the exhaust stream and the urea exhaust treatment fluid, a mixing assembly 80 may be positioned downstream from inlet 66 and upstream of SCR 70. Mixing assembly 80 is positioned proximate dosing module 28 such that dosing module 28 may dose the urea exhaust treatment fluid directly into mixing assembly 80 where it may intermingle with the exhaust stream.

FIGS. 7-9 illustrate a first exemplary embodiment of mixing assembly 80. Mixing assembly 80 includes a decomposition tube 82 including a first end portion 84 that may be secured to end cap 74 and a second end portion 86 that is positioned proximate SCR 70. Decomposition tube 82 may be substantially cylindrical, with a radially expanded portion 88 positioned between the first and second end portions 84 and 86. Radially expanded portion 88 includes a conically-expanding portion 90 that expands the decomposition tube 82, a cylindrical portion 92 downstream from the conically-expanding portion 90 having a diameter that is greater than that of first and second end portions 84 and 86, and a conically-narrowing portion 94 that narrows decomposition tube 82. It should be understood that first and second end portions 84 and 86 may have different diameters, without departing from the scope of the present disclosure. It should also be understood that the present disclosure does not require conically-narrowing portion 94. That is, radially expanded portion 88 may extend over the entire length of second end portion 86.

First end portion 84 may be perforated such that first end portion 84 includes a plurality of first perforations 96. First perforations 96 can vary in size around the circumference of

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first end portion **84**, and assist in creating turbulence and increasing a velocity of the exhaust stream as it enters decomposition tube **82**. Although not required by the present disclosure, a perforated collar **98** including a plurality of second perforations formed as elongate slots **100** may be positioned around and secured to first end portion **84**. Perforated collar **98** includes a cylindrical portion **102** having a diameter greater than that of first end portion **84**. Cylindrical portion **102** radially narrows into an axially-extending flange **104** that may be fixedly coupled to decomposition tube **82** at a position proximate radially expanded portion **88** by welding, brazing, or any other secure attachment method known to one skilled in the art.

Elongate slots **100** may be dimensioned larger than first perforations **96**. Elongate slots **100** can be oriented in various directions including directions parallel with an axis of decomposition tube **82**, and directions arranged orthogonal to the axis of decomposition tube **82**. It should be understood, however, that each elongate slot **100** can be oriented in the same direction without departing from the scope of the present disclosure. Similar to first perforations **96**, elongate slots **100** assist in creating turbulence and increasing a velocity of the exhaust stream as it enters decomposition tube **82**.

Mixing assembly **80** includes a flow reversing device **106** at second end portion **86**. Flow reversing device **106** may be fixed to second end portion **86**, or may be supported by a baffle (not shown) that secures flow reversing device **106** to end cap **74** at a position proximate terminal edge **108** of second end portion **86**. Flow reversing device **106** is a substantially cup-shaped member **110** having a central bulge **112** formed therein. Flow reversing device **106** has a diameter greater than that of second end portion **86** of decomposition tube **82** such that as the exhaust flow enters the cup-shaped member **110**, the exhaust flow will be forced to flow in a reverse direction back toward inlet **66** of housing **64**. The reversing of the exhaust flow assists in intermingling of the reagent exhaust treatment fluid and the exhaust stream before the exhaust stream reaches SCR **70**.

Flow reversing device **106** may include a plurality of deflecting members **114** to further assist in intermingling the reagent exhaust treatment fluid and the exhaust stream. Deflecting members **114** may be formed as a plurality of vanes that extend radially inward from an inner surface **116** of outer wall **118** of flow reversing device **106**. In addition to extending radially inward, vanes **114** may also be angled relative to an axis of decomposition tube **82** to further direct the exhaust flow as it exits flow reversing device **106**. Vanes **114** may be planar members, or may be slightly curved. Although vanes **114** are illustrated as being secured to inner surface **116** of flow-reversing device **106**, it should be understood that vanes **114** may be secured to second end portion **86** of decomposition tube **82**.

As illustrated in FIG. 6, mixing assembly **80** may be arranged in a direction orthogonal to an axis of inlet **66**. The exhaust stream, therefore, will enter mixing assembly **80** orthogonally before being directed toward SCR **70**. As the exhaust stream enters first end **84** of decomposition tube **82**, a velocity of the exhaust stream may increase and the flow of the exhaust stream will become tortuous due to first and second perforations **96** and **100**. As the exhaust enters radially expanded portion **88**, the flow may tend to stay along the axis of the decomposition tube **82**. Although the velocity of the exhaust stream may slow, the velocity only slows to a minimal extent that ensures satisfactory intermingling of the exhaust and reagent exhaust treatment fluid. In this regard, radially expanded portion **88** diffuses the turbulence in the exhaust flow created by perforations **96** and **100**, which aids in mini-

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mizing any potential loss in velocity. Table 1, below, summarizes the peak velocity of the exhaust stream at various regions within exhaust treatment component **20**.

TABLE 1

Region	Peak Velocity (m/S)
A	84
B	120
C	102
D	102
E	120
F	120
G	25

As can be seen in Table 1 and FIG. 6, as the exhaust stream enters from inlet **66**, the exhaust may have a peak velocity of 84 m/s (Region A). As the exhaust enters mixing assembly **80** through collar **98** and first end portion **84** of decomposition tube **82**, the velocity may increase (Region B). The increase in velocity at region B creates a large velocity differential between a velocity of the exhaust treatment fluid injected by dosing module **28** and the exhaust gas flowing through perforations **96** and **100**. The velocity differential of the bulk exhaust flow results in aerodynamic forces greater than the surface tension characteristic of the exhaust treatment fluid, which leads to droplet breakup and atomization of the exhaust treatment fluid.

Then, as the exhaust enters radially expanded portion **88**, the exhaust may slightly slow (Regions C and D). As the exhaust exits radially expanded portion and enters flow reversing device **106**, the velocity may then increase (Regions E and F). The exhaust velocity may then decrease as the exhaust reaches SCR **70** (Region G). Because the exhaust velocity increases at a location (Region B) where the exhaust treatment fluid is dosed into the exhaust stream, and increases as it exits flow reversing device **106**, the exhaust and exhaust treatment fluid can be sufficiently intermingled to ensure satisfactory atomization of the exhaust treatment fluid.

Regardless, while the exhaust stream is in radially expanded portion **88** (Region D), zones **120** of low velocity flow are present at positions adjacent inner walls **122** of decomposition tube **82** (FIG. 9). These zones **120** surround the exhaust stream as it passes through radially expanded portion **88**, and assist in preventing wetting of inner walls **122** with the reagent exhaust treatment fluid. The prevention of the inner walls **122** being wetted prevents, or at least substantially minimizes, the build-up of solid urea deposits on the inner walls **122**.

As the exhaust stream enters second end portion **86** of decomposition tube **82**, a velocity of the exhaust stream will again increase and remain increased as it enters and exits flow reversing device **106**. Upon entry into flow reversing device **106**, the flow direction of the exhaust stream will be reversed back toward inlet **66**. As the exhaust flow exits flow reversing device **106**, the exhaust will be directed by vanes **114**, which will assist in further intermingling of the exhaust and reagent exhaust treatment fluid. Additionally, the exhaust stream may impinge upon conically-narrowing portion **94** of decomposition tube **82**, which can further assist in directing the exhaust stream away from mixing assembly **80**. The exhaust stream is then free to flow towards SCR **70**.

Now referring to FIGS. 10 to 13, a second exemplary mixing assembly **200** will be described. Mixing assembly **200** is similar to mixing assembly **80** illustrated in FIGS. 7 to 9. Description of components that are common to each assembly, therefore, is omitted herein for clarity. Mixing assembly

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200 includes deflecting device 202 including a plurality of deflecting members 204. As best shown in FIG. 13, deflecting device 202 may be formed from an elongate strip 206 of metal such as aluminum, steel, titanium, or any other material known to one skilled in the art. Deflecting members 204 are integral (i.e., unitary) with elongate strip 206 and are formed as planar tabs that are bent radially outward from elongate strip 206 from a plurality of cut-outs 208 formed in elongate strip 206.

Deflecting members 204 may be designed to function in a manner similar to vanes 114. In this regard, as the exhaust flow exits flow reversing device 106, the exhaust will be directed by deflecting members 204, which will assist in further intermingling of the exhaust and reagent exhaust treatment fluid. As best shown in FIGS. 12 and 13, cut-outs 208 are angled relative to a length of elongate strip 206. When deflecting members 204 are bent outward from elongate strip 206, deflecting members 204 will also be angled relative to an axis of mixing assembly 200, which may be used to direct the exhaust flow in predetermined directions upon exiting flow reversing device 106.

Deflecting members 204 may have a length that is substantially equal to a distance between second end portion 86 of decomposition tube 82 and outer wall 118 of flow reversing device 106. Alternatively, deflecting members 204 may have a length that is less than the distance between second end portion 86 and outer wall 118. In another alternative, deflecting members 204 may each have a terminal projection 210 that provides deflecting members 204 with a length that is greater than the distance between second end portion 86 and outer wall 118. Terminal projection 210 may then abut a terminal end 212 of outer wall 118 of flow reversing device 106, which assists in positioning deflecting device 202 relative to flow reversing device 106. Terminal projections 210 may also assist in securing deflecting device 202 to flow reversing device 106, by providing a location to weld, braze, or secure each tab to flow reversing device 106, if desired.

Now referring to FIGS. 14 to 16, a third exemplary mixing assembly 300 is illustrated. Mixing assembly 300 is substantially similar to mixing assembly 80 illustrated in FIGS. 7 to 9. Description of components that are common to each assembly, therefore, is omitted herein for clarity. Although collar 98 is not illustrated in FIG. 14, it should be understood that mixing assembly 300 may include collar 98. Mixing assembly 300 includes deflecting device 302 including a plurality of deflecting members 304. As best shown in FIG. 15, deflecting device 302 may be formed from an annular ring 306 of metal such as aluminum, steel, titanium, or any other material known to one skilled in the art. Deflecting members 304 are integral (i.e., unitary) with annular ring 306 and are formed as planar tabs that may be bent axially outward from annular ring 306 from a plurality of cut-outs 308 formed in annular ring 306. Although deflecting members 304 are illustrated as being bent in a direction toward an interior 310 of flow reversing device 106, it should be understood that deflecting members 304 can be bent in a direction away from interior 310.

Deflecting members 304 may be designed to function in a manner similar to vanes 114. In this regard, as the exhaust flow exits flow reversing device 106, the exhaust will be directed by deflecting members 304, which will assist in further intermingling of the exhaust and reagent exhaust treatment fluid. Deflecting members 304 may also be angled relative to an axis of mixing assembly 300, which may be used to direct the exhaust flow in predetermined directions upon exiting flow reversing device 106.

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Once deflecting members 304 are bent into the desired orientation, an inner ring 312 and an outer ring 314 of deflecting device will be defined. Inner ring 312 may be used to secure deflecting device 302 to second end portion 86 of decomposition tube 82 by welding, brazing, or any other fixing method known in any manner known to one skilled in the art. Deflecting device 302 may also include an axially-extending flange 316 that extends outward from outer ring 314. Axially-extending flange 316 may correspond to terminal end 212 of flow reversing device 106 (FIG. 11), and overlap terminal end 212 such that axially-extending flange 316 may be secured to flow reversing device 106 by welding, brazing, or any other attachment method known.

Now referring to FIGS. 17 to 19, a fourth exemplary embodiment is illustrated. Mixing assembly 400 is similar to mixing assembly 80 illustrated in FIGS. 7 to 9. Description of components that are common to each assembly, therefore, is omitted herein for clarity. Mixing assembly 400 includes flow reversing device 106 at second end portion 86, which is a substantially cup-shaped member having a central bulge formed therein. In contrast to deflecting members 204 and 304 described above, mixing assembly 400 may include a flow-dispersing cap 402 coupled between flow reversing device 106 and decomposition tube 82.

Flow-dispersing cap 402 includes a first axially-extending lip 404 that couples flow-dispersing cap 402 to flow reversing device 106, and a second axially-extending lip 406 that couples flow-dispersing cap 402 to decomposition tube 82. Between axially-extending lips 404 and 406 is a perforated conically-shaped ring 408 having a plurality of through-holes 410. Similar to first and second perforations 96 and 100, through-holes 410 assist in creating turbulence and increasing a velocity of the exhaust stream as it exits flow reversing device 106. Through-holes 410 can be sized and shaped in any manner desired. In this regard, although through-holes 410 are illustrated as being circular, it should be understood that through-holes can be any shape including square, rectangular, triangular, oval, and the like. Conically-shaped ring 408 can include a first portion 412 adjacent first axially-extending lip 404, and a second portion 414 adjacent second axially-extending lip 406.

A diverter ring 416 may be positioned between second portion 414 and decomposition tube 82. As best shown in FIG. 19, diverter ring 416 includes a cylindrical portion 418 coupled to decomposition tube 82, and an angled flange 420 extending away from cylindrical portion 418 between decomposition tube 82 and conically-shaped ring 408. Angled flange 420 may be positioned at any angle desired to further assist in diverting flow out from mixing assembly 400. In this regard, angled flange may be angled relative to cylindrical portion 418 in the range of 25 to 75 degrees, preferably in the range of 35 to 65 degrees, and most preferably at an angle of degrees.

Upon entry into flow reversing device 106, the flow direction of the exhaust stream will be reversed back toward inlet 66. As the exhaust flow exits flow reversing device 106, the exhaust will be directed by diverter ring 416 out through through-holes 410, which will assist in further intermingling of the exhaust and reagent exhaust treatment fluid. The exhaust stream is then free to flow towards SCR 70.

Now referring to FIGS. 20 and 21, a fifth exemplary embodiment is illustrated. Mixing assembly 500 is substantially similar to mixing assembly 80 illustrated in FIGS. 7 to 9. Description of components that are common to each assembly, therefore, is omitted herein for clarity. Mixing assembly 500 includes flow reversing device 502 at second end portion 86 of decomposition tube 82, which is a substan-

tially cup-shaped member having a central bulge **503** formed therein. Flow reversing device **502** may include a plurality of flow deflecting members **504** formed in an outer wall **506** thereof. Deflecting members **504** are integral (i.e., unitary) with flow reversing device **502** and are formed as planar tabs that are bent radially outward from outer wall **506** from a plurality of cut-outs **508** formed in outer wall **506**. Deflecting members **504** may be designed to function in a manner similar to vanes **114**. In this regard, as the exhaust flow exits flow reversing device **502** through cut-outs **508**, the exhaust flow will become turbulent and deflected by deflecting members **504**, which will assist in further intermingling of the exhaust and reagent exhaust treatment fluid.

Mixing assembly **500** may further include a dispersing ring **510** positioned between a terminal end **512** of flow reversing device **502** and decomposition tube **82**. Dispersing ring **510** may be formed from an annular ring **514** of metal such as aluminum, steel, titanium, or any other material known to one skilled in the art. A cylindrical flange **516** may extend axially away from annular ring **514**. Cylindrical flange **516** may be welded, brazed, or secured in any manner known, to decomposition tube **82**. Annular ring **514** includes a plurality of scallop-shaped recesses **518** formed therein. Recesses **518** serve as exit ports to allow the exhaust stream to exit mixing assembly **500**. Accordingly, the exhaust stream may exit through cut-outs **508**, or may exit through recesses **518**. Adjacent recesses **518** may be separated by a land portion **520** of the annular ring **514**. A terminal end **522** of each land portion **520** located opposite to cylindrical flange **516** may be bent in the axial direction to provide an abutment surface that can position dispersing ring **510** relative to flow reversing device **502** before dispersing ring **510** is secured to decomposition tube **82**.

Upon entry into flow reversing device **502**, the flow direction of the exhaust stream will be reversed back toward inlet **66**. As the exhaust flow exits flow reversing device **502**, the exhaust may exit through cut-outs **508** and be deflected in a desired direction by deflecting members **504**, or the exhaust stream may exit through recesses **518** formed in dispersing ring **510**. Regardless of the location at which the exhaust stream exits mixing assembly **500**, the exhaust stream is further intermingled with the reagent exhaust treatment fluid before flowing toward SCR **70**.

Although each mixing assembly has been described relative to use in an exhaust treatment component **20** including a single SCR **70**, the present disclosure should not be limited thereto. As best shown in FIGS. **22** and **23**, mixing assemblies can be used in an exhaust treatment component **20** having a pair of SCRs **70**. FIG. **22** illustrates a pair of exhaust treatment components **18** and **20**, arranged in parallel. Exhaust treatment component **18** is similar to the previously-described embodiments so description thereof will be omitted.

Exhaust treatment component **20**, as best shown in FIG. **23**, includes mixing assembly **80** (or any other mixing assembly described above) for intermingling exhaust treatment fluid dosed into the exhaust stream by dosing module **28**. Exhaust treatment component **20** includes a pair of housings **600** in communication with a pair of end caps **602** and **604**. End caps **602** and **604** may be secured to housings **600** by welding, or may be secured to housings **600** by clamps (not shown). Mixing assembly **80** and dosing module **28** are secured in a conduit **606** that provides communication between exhaust treatment component **18** and exhaust treatment component **20**. Conduit **606** may include a first portion **608** and a second portion **610** each including a flange **612** and **614**, respectively, that may be secured by welding, or by a clamp (not shown). Each housing **600** supports a plurality of exhaust treatment

component substrates **618**, which may be a combination of SCRs, ammonia slip catalysts, and filters for treating the mixture of exhaust and exhaust treatment fluid.

As the exhaust enters mixing assembly **80**, the urea exhaust treatment fluid may be dosed directly into mixing assembly **80** by dosing module **28**. As the mixture of exhaust and exhaust treatment fluid travels through decomposition tube **82** and flow reversing device **106**, the exhaust treatment fluid and exhaust stream will be sufficiently intermingled before passing through exhaust treatment component substrates **618**. Mixing assembly **80** may include deflecting members or vanes **114** to assist in intermingling the exhaust and exhaust treatment fluid. Because a pair of housings **600** each including exhaust treatment component substrates **618** is used in the exemplary embodiment, vanes **114** may be positioned within flow reversing device **106** to ensure that a substantially equal amount of the exhaust stream is directed to each housing **600**. That is, it should be understood that deflecting members **114** (and the deflecting members in each exemplary embodiment) can be oriented and positioned to direct the exhaust in the desired direction. In this manner, the exhaust can be properly treated by exhaust treatment component substrates **618**.

The foregoing description of the embodiments has been provided for purposes of illustration and description. It is not intended to be exhaustive or to limit the disclosure. Individual elements or features of a particular embodiment are generally not limited to that particular embodiment, but, where applicable, are interchangeable and can be used in a selected embodiment, even if not specifically shown or described. The same may also be varied in many ways. Such variations are not to be regarded as a departure from the disclosure, and all such modifications are intended to be included within the scope of the disclosure.

What is claimed is:

1. An exhaust mixing device for mixing an exhaust produced by an engine with a reagent exhaust treatment fluid that is injected into the exhaust, comprising:

a decomposition tube having a first end and a second end, the first end of the decomposition tube configured to receive the exhaust and the reagent exhaust treatment fluid; and

a flow reversing device positioned at the second end of the decomposition tube, the flow reversing device including a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions, wherein the deflecting members are comprised of a diverter ring fixed at the second end of the decomposition tube,

wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube.

2. The exhaust mixing device of claim 1, wherein the first end includes a plurality of first perforations that receive the exhaust.

3. The exhaust mixing device of claim 2, further comprising a collar disposed about the first end, the collar including a plurality of second perforations that receive the exhaust.

4. The exhaust mixing device of claim 1, further comprising a flow-dispersing cap secured between the second end of the decomposition tube and the flow reversing device, the flow-dispersing cap including a plurality of through-holes formed therein.

5. The exhaust gas mixing device of claim 1, wherein the decomposition tube includes a radially expanded portion between the first and second ends.

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6. An exhaust mixing device for mixing an exhaust produced by an engine with a reagent exhaust treatment fluid that is injected into the exhaust, comprising:

a decomposition tube having a first end and a second end, the first end of the decomposition tube configured to receive the exhaust and the reagent exhaust treatment fluid; and

a flow reversing device positioned at the second end of the decomposition tube, the flow reversing device including a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions,

wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube, and further wherein the deflecting members include a plurality of vanes, and the vanes are fixed to an inner surface of the flow reversing device.

7. An exhaust mixing device for mixing an exhaust produced by an engine with a reagent exhaust treatment fluid that is injected into the exhaust, comprising:

a decomposition tube having a first end and a second end, the first end of the decomposition tube configured to receive the exhaust and the reagent exhaust treatment fluid; and

a flow reversing device positioned at the second end of the decomposition tube, the flow reversing device including a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions,

wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube, and further wherein deflecting members include a plurality of tabs that protrude from a plurality of cut-outs formed about a circumference of the flow reversing device.

8. The exhaust mixing device of claim 7, further comprising a dispersing ring having a plurality of scallop-shaped recesses fixed between the second end of the decomposition tube and the flow reversing device.

9. The exhaust mixing device of claim 7, wherein the deflecting members are positioned about a cylindrical ring secured at the second end of the decomposition tube.

10. The exhaust mixing device of claim 7, wherein the deflecting members are positioned about an annular ring secured between the second end of the decomposition tube and the flow reversing device.

11. An exhaust treatment component for treating an exhaust produced by an engine, comprising:

a housing;

a first exhaust treatment component substrate positioned within the housing;

a dosing module for dosing a reagent exhaust treatment fluid into the exhaust, the dosing module secured to the housing and positioned upstream of the first exhaust treatment component substrate;

a mixing device positioned downstream from the dosing module and upstream from the first exhaust treatment component substrate, the mixing device including a decomposition tube having a first end directly communicating with the dosing module and a second end having a flow reversing device disposed proximate thereto, the flow reversing device including a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions,

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tions, wherein the deflecting members are formed from a plurality of tabs that protrude from a plurality of cut-outs formed about a circumference of the flow reversing device,

wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube.

12. The exhaust treatment component of claim 11, wherein the first end includes a plurality of first perforations that receive the exhaust.

13. The exhaust treatment component of claim 12, further comprising a collar disposed about the first end, the collar including a plurality of second perforations that receive the exhaust.

14. The exhaust treatment component of claim 11, further comprising a dispersing ring having a plurality of scallop-shaped recesses fixed between the second end of the decomposition tube and the flow reversing device.

15. The exhaust treatment component of claim 11, wherein the deflecting members are formed about a cylindrical ring secured at the second end of the decomposition tube.

16. The exhaust treatment component of claim 11, wherein the decomposition tube includes a radially expanded portion between the first and second ends.

17. The exhaust treatment of claim 11, wherein the first exhaust treatment component substrate is a selective catalytic reduction (SCR) catalyst substrate.

18. The exhaust treatment component of claim 17, further comprising a second exhaust treatment component positioned with the housing, and arranged in parallel with the first exhaust treatment component.

19. The exhaust treatment component of claim 18, wherein the second exhaust treatment component is an SCR catalyst substrate.

20. The exhaust treatment component of claim 18, wherein the second exhaust treatment component is a diesel oxidation catalyst (DOC) substrate or a particulate filter substrate.

21. An exhaust treatment component for treating an exhaust produced by an engine, comprising:

a housing;

a first exhaust treatment component substrate positioned within the housing;

a dosing module for dosing a reagent exhaust treatment fluid into the exhaust, the dosing module secured to the housing and positioned upstream of the first exhaust treatment component substrate; and

a mixing device positioned downstream from the dosing module and upstream from the first exhaust treatment component substrate, the mixing device including a decomposition tube having a first end directly communicating with the dosing module and a second end having a flow reversing device disposed proximate thereto, the flow reversing device including a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions,

wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube, and further wherein the deflecting members are formed about an annular ring secured between the second end of the decomposition tube and the flow reversing device.

22. An exhaust treatment component for treating an exhaust produced by an engine, comprising:

a housing;

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a first exhaust treatment component substrate positioned within the housing;

a dosing module for dosing a reagent exhaust treatment fluid into the exhaust, the dosing module secured to the housing and positioned upstream of the first exhaust treatment component substrate; and

a mixing device positioned downstream from the dosing module and upstream from the first exhaust treatment component substrate, the mixing device including a decomposition tube having a first end directly communicating with the dosing module and a second end having a flow reversing device disposed proximate thereto, the flow reversing device including a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions,

wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube, and further wherein the deflecting members are comprised of a diverter ring fixed at the second end of the decomposition tube.

23. The exhaust treatment component of claim **22**, further comprising a flow-dispersing cap secured between the second end of the decomposition tube and the flow reversing device, the flow-dispersing cap including a plurality of through-holes formed therein.

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24. An exhaust treatment component for treating an exhaust produced by an engine, comprising:

a housing;

a first exhaust treatment component substrate positioned within the housing;

a dosing module for dosing a reagent exhaust treatment fluid into the exhaust, the dosing module secured to the housing and positioned upstream of the first exhaust treatment component substrate; and

a mixing device positioned downstream from the dosing module and upstream from the first exhaust treatment component substrate, the mixing device including a decomposition tube having a first end directly communicating with the dosing module and a second end having a flow reversing device disposed proximate thereto, the flow reversing device including a plurality of deflecting members that intermix the exhaust and reagent exhaust treatment fluid, and direct the exhaust and reagent exhaust treatment fluid in predetermined directions,

wherein the flow reversing device reverses a flow direction of the exhaust back towards the first end of the decomposition tube, and further wherein the deflecting members are formed as a plurality of vanes, and the vanes are fixed to an inner surface of the flow reversing device.

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